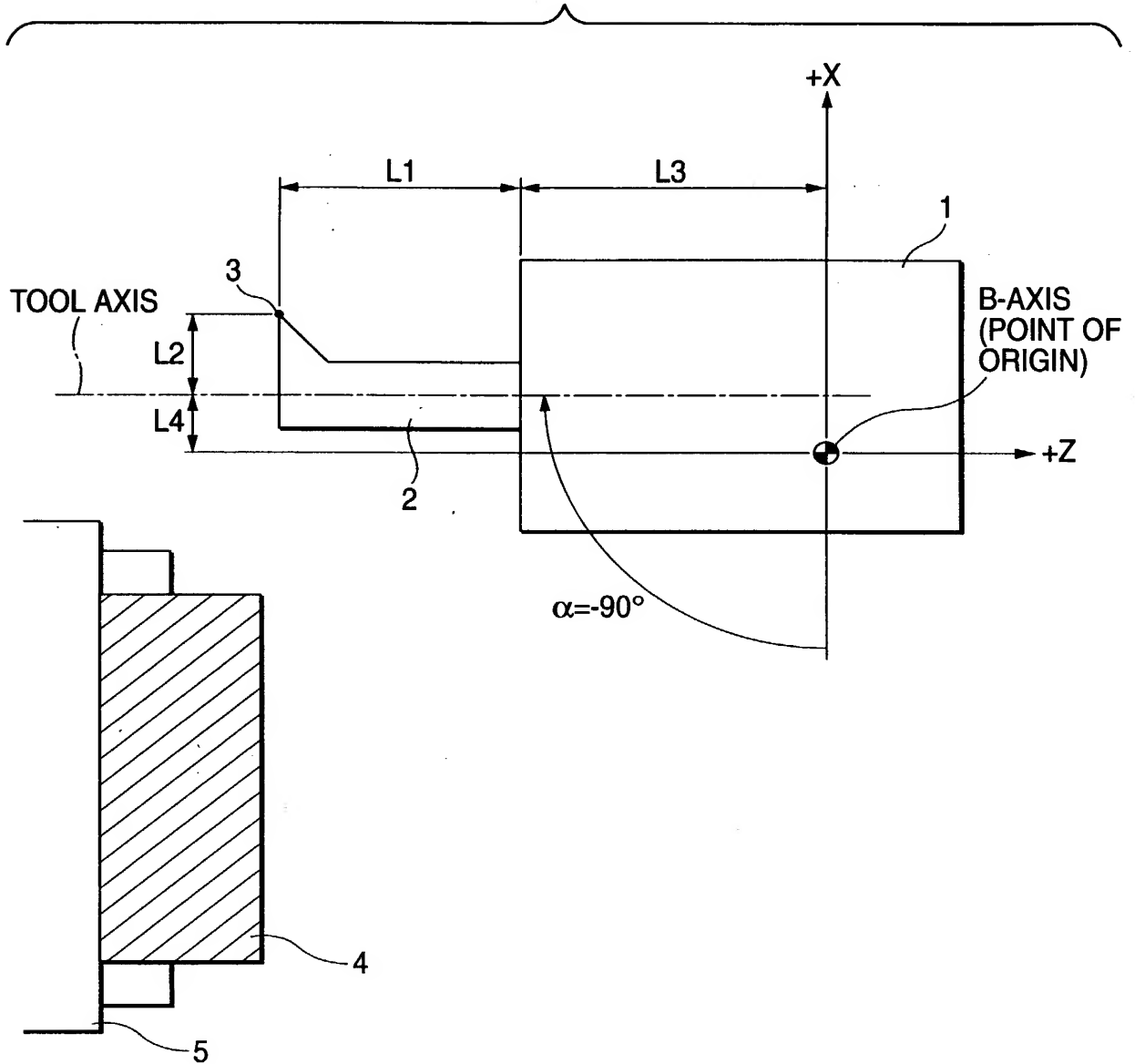


FIG. 1



100

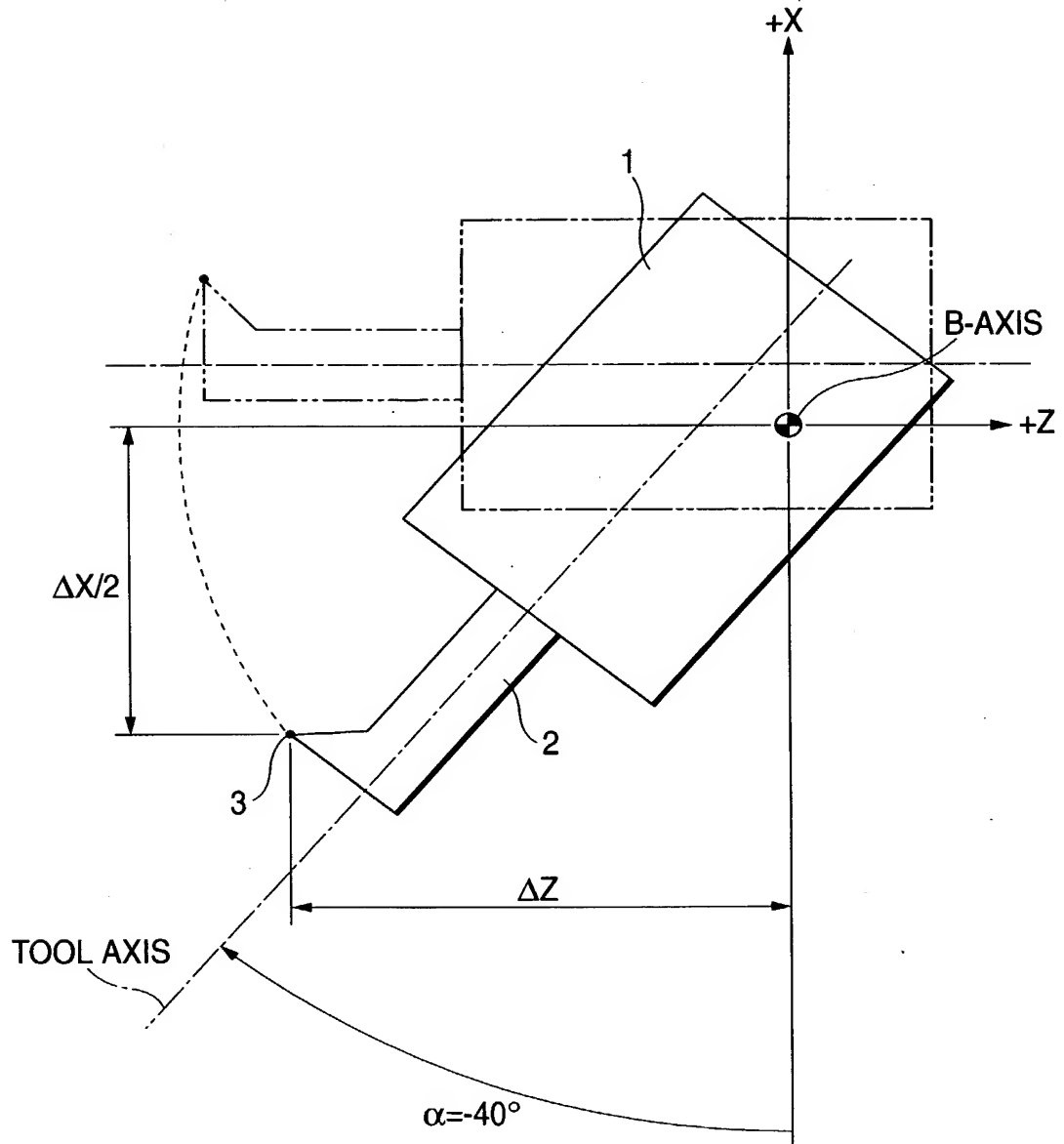


FIG. 3

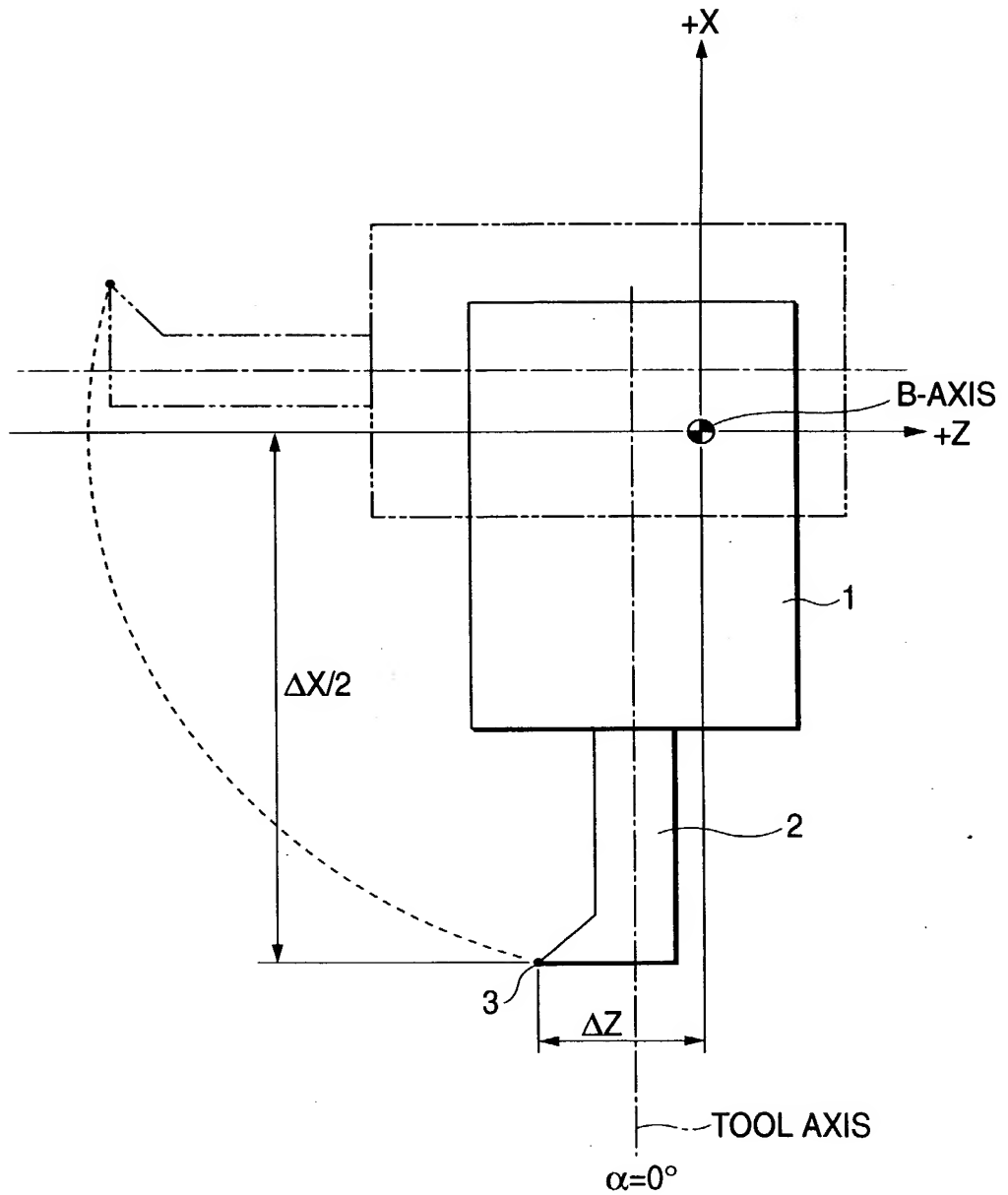
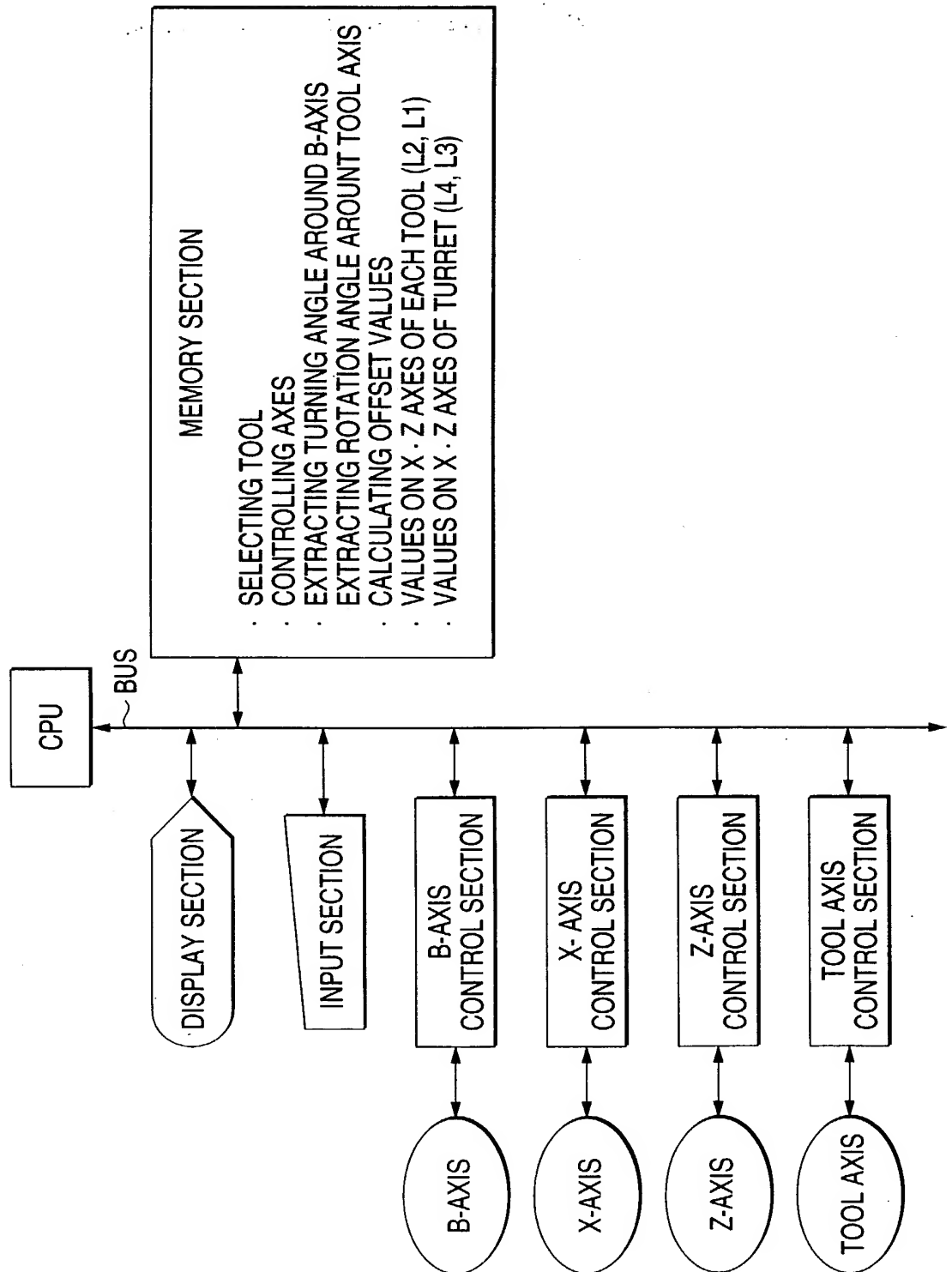


FIG. 4



TOOL	TURNING ANGLE	OFFSET ON X AXIS (ΔX)	OFFSET ON Z AXIS (ΔZ)
TURNING	-90.0° (INITIAL POSITION)	-22.00 (ΔX_0)	400.00 (ΔZ_0)
	-40.0°	598.69	265.54
(WEAR COMPENSATION VALUE)		ΔX_t	ΔZ_t
		-0.09	-0.04
		-0.24	-0.09
		-0.29	-0.14

TURNING	0.0°	800.00	11.00

FIG. 5

FIG. 6

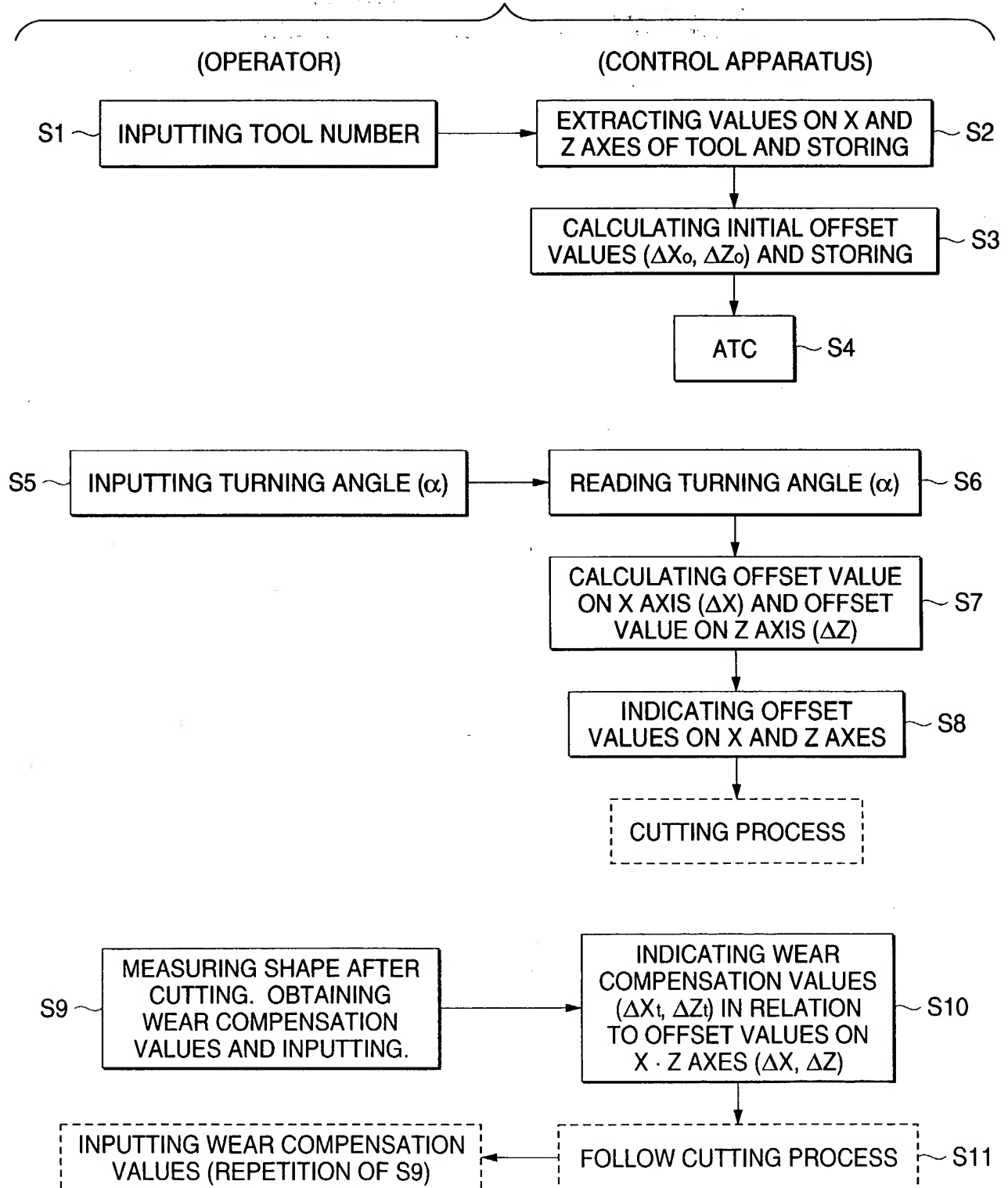


FIG. 7

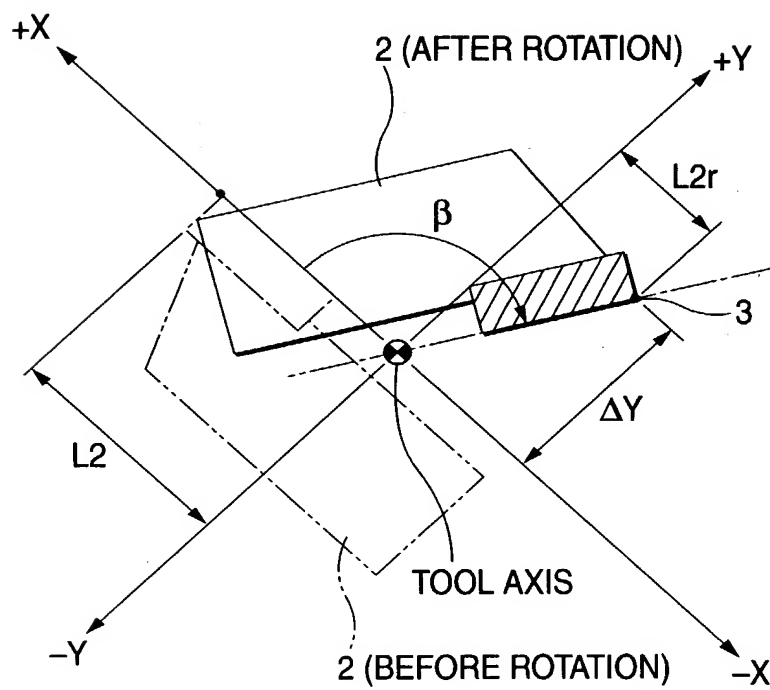


FIG. 8

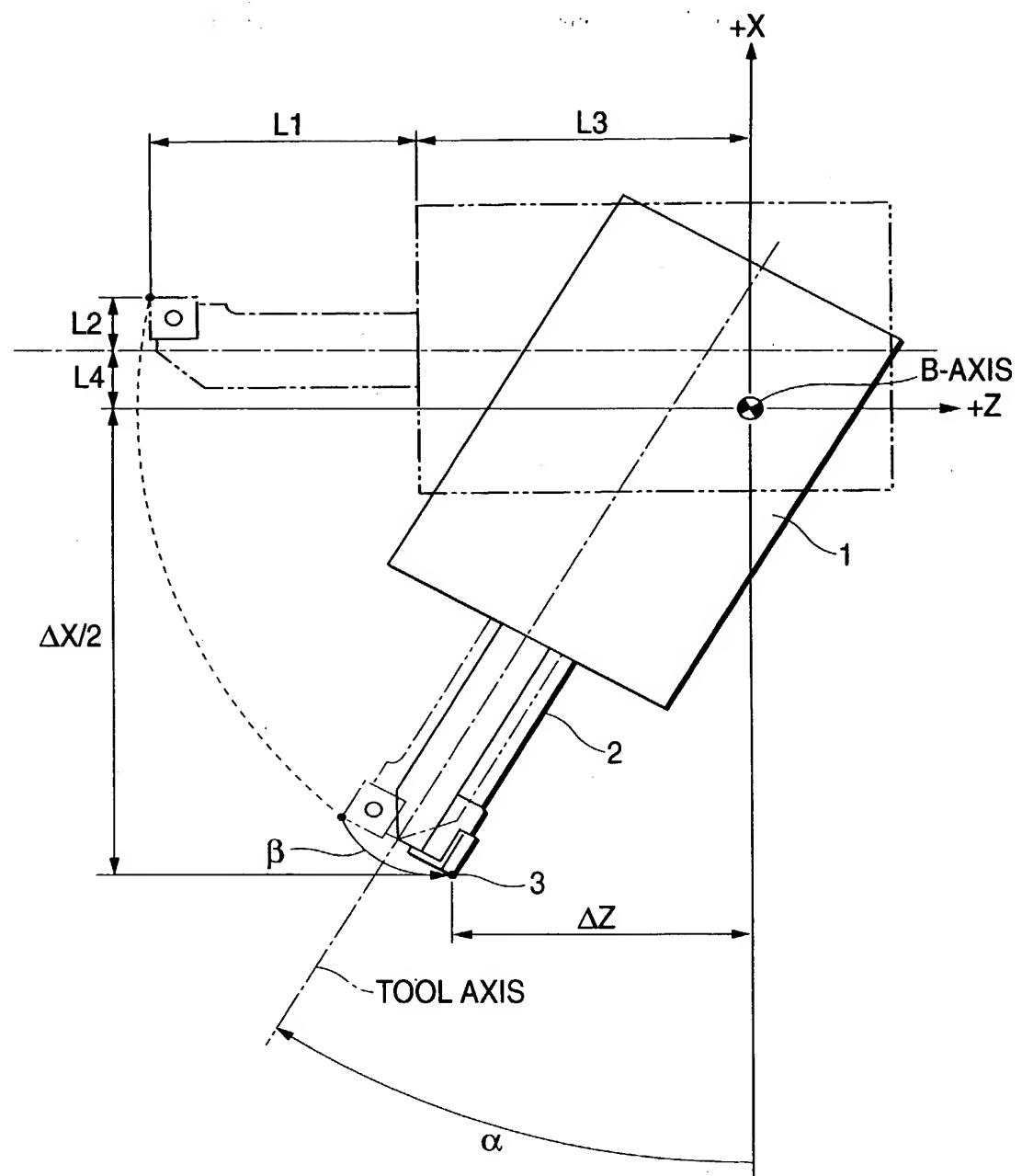


FIG. 9

TOOL	TURNING ANGLE (α)	ROTATION ANGLE (β)	OFFSET ON X AXIS (ΔX)	OFFSET ON Z AXIS (ΔZ)	OFFSET ON Y AXIS (ΔY)
TURNING	-90.0° (INITIAL POSITION)	0.0°	-22.00 (ΔX_0)	400.00 (ΔZ_0)	0.00 (ΔY_0)
	-40.0°	0.0°	598.69	265.54	0.00
	-40.0°	120.0°	617.98 (ΔX_t)	254.05 (ΔZ_t)	-8.66
	(WEAR COMPENSATION VALUE)		ΔX_t	ΔZ_t	ΔY_t
			-0.08	-0.05	-0.06
			-0.13	-0.10	-0.10